

Work Order ID 148591-2

Tuesday, July 05, 2016 3:09:25 PM

646.3001

B 148591

148591

Page 1

Item ID: 646.3001

Revision ID:

Item Name: Lower Cutter Assembly

Start Date: 6/30/2016 Start Qty: 2.00

Required Date: 7/14/2016 Req'd Qty: 2.00

Reference:

REV. N / C Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: DAS

Date: JUL 12 2016 Tooling: Date:

QC: 21

Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3000	N/C								

110 Pick Kit 0.00

110

Packaging Memo 0.01

Packaging

120 0.00

120

Small Fab Memo 0.24

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.

A/R RTV LOCTITE 598: 135479

exp. date: 01/18

4X 16/10/11 DAS 36 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.07				<u>4</u>			DAS 38 9-89
Quality Control									OCT 12 2016
140	Identify as per dwg & Stock Location <u>CC1016</u>	0.00							
140									
Packaging	Memo	0.00				<u>4</u>			DAS 6 9-89
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***							OCT 12 2016	
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.01					DAS 21 9-89		OCT 13 2016
Quality Control									
							DAS 21 9-89		OCT 12 2016

Picklist Print

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Work Order ID: 148591

148591

Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assembly

Start Date: 6/30/2016

Required Date: 7/14/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21042L08

Purchased

No

Each

1,246.000

19 38-95

MS21042L 08

Nut

Location	Loc Qty	Loc Code
GA	262	
m133134	3	
m134063	259	
ST303	967	
m133922	37	
m134574	4	
m134654	276	
m134962	200	
m135046	350	
m135133	100	
ST308	17	
m134376	17	

646.3010

Manufactured

No

110

Each

26.0000

1

25

646.3010

LH Half

Location	Loc Qty	Loc Code
cck102	14	
142499	14	
CCK108A	12	
142499	12	

L

ALL 7 0 7016

Picklist Print

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Work Order ID: 148591

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Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assembly

Start Date: 6/30/2016

Required Date: 7/14/2016

Start Qty: 2.00

Required Qty: 2.00

646.3011

Manufactured No

110

Each

9.0000

1

25

646.3011

RH Half

Location

Loc Qty

Loc Code

cck102

9

142473

9

5

646.3012

Manufactured No

110

Each

0.0000

1

25

646.3012

Lower Guide

140006

646.3013

Manufactured No

110

Each

10.0000

1

25

646.3013

Blade

Location

Loc Qty

Loc Code

cck103

10

142489

10

5

646.3014

Manufactured No

110

Each

11.0000

1

25

646.3014

Blade

Location

Loc Qty

Loc Code

cck103

11

142467

11

5

646.3015

Manufactured No

110

Each

9.0000

1

25

646.3015

Blade

147542

Location

Loc Qty

Loc Code

cck103

9

141062

9

5

AUG 29 2016

Picklist Print

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Work Order ID: 148591

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Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assembly

Start Date: 6/30/2016

Required Date: 7/14/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

634.0000

19

38-75

MS27039-08-19

Screw

135466

Location

Loc Qty

Loc Code

GA

370

m132930

84

m133077

22

m134063

76

m134294

88

m135046

100

ST277

264

m134142

164

m135133

100

NAS1149FN832P

Purchased

No

110

Each

3,224.000

38

76-190

NAS1149FN832P

Washer

Location

Loc Qty

Loc Code

GA

361

M133316

16

M133769

345

ST260a

2800

M134257

1200

M135058

1600

ST263

63

M133709

63

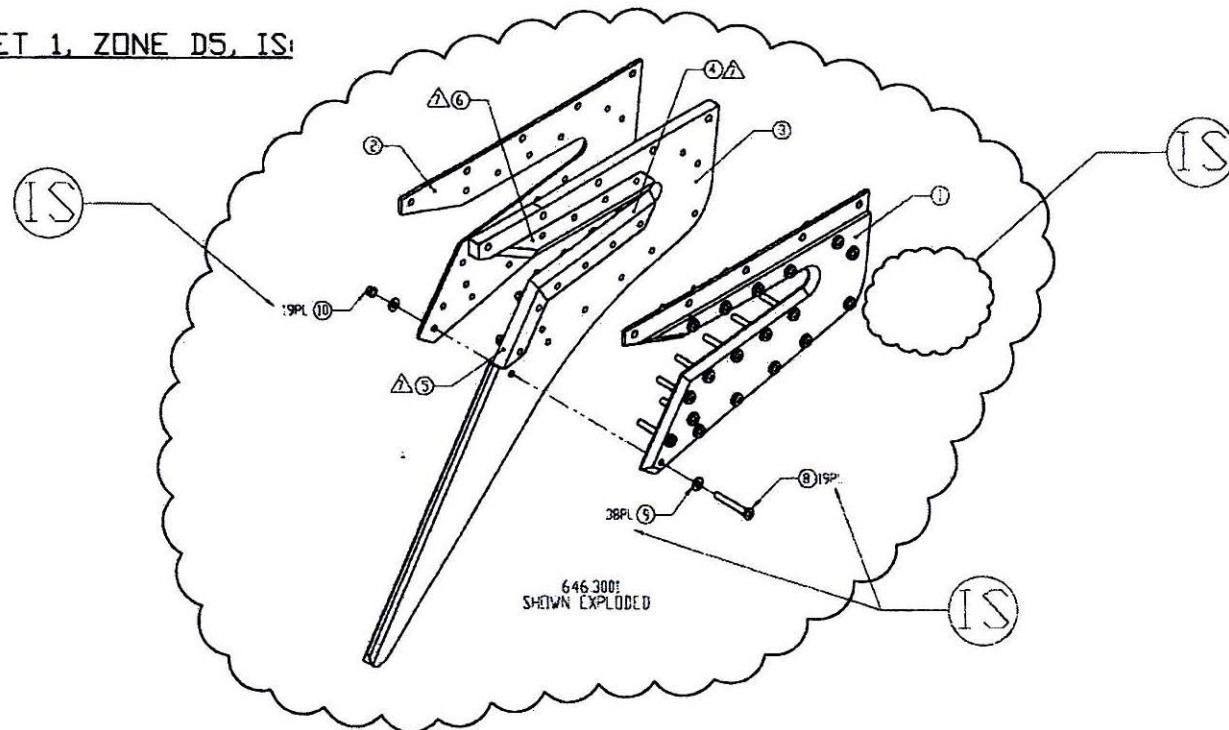
AUG 29 2016

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 02195		SHEET 1 OF 4	
DWG NO. 646.3000	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
DWG TITLE: LOWER CUTTER ASSY		EFFECT ON DWG ☐ INC. ☒ UNINC.	
APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER
REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

TRANSACTION CODES (TC)
A-ADD C-CREATE
R-REVISE D-DELETE

SHEET 1, ZONE D5, IS:

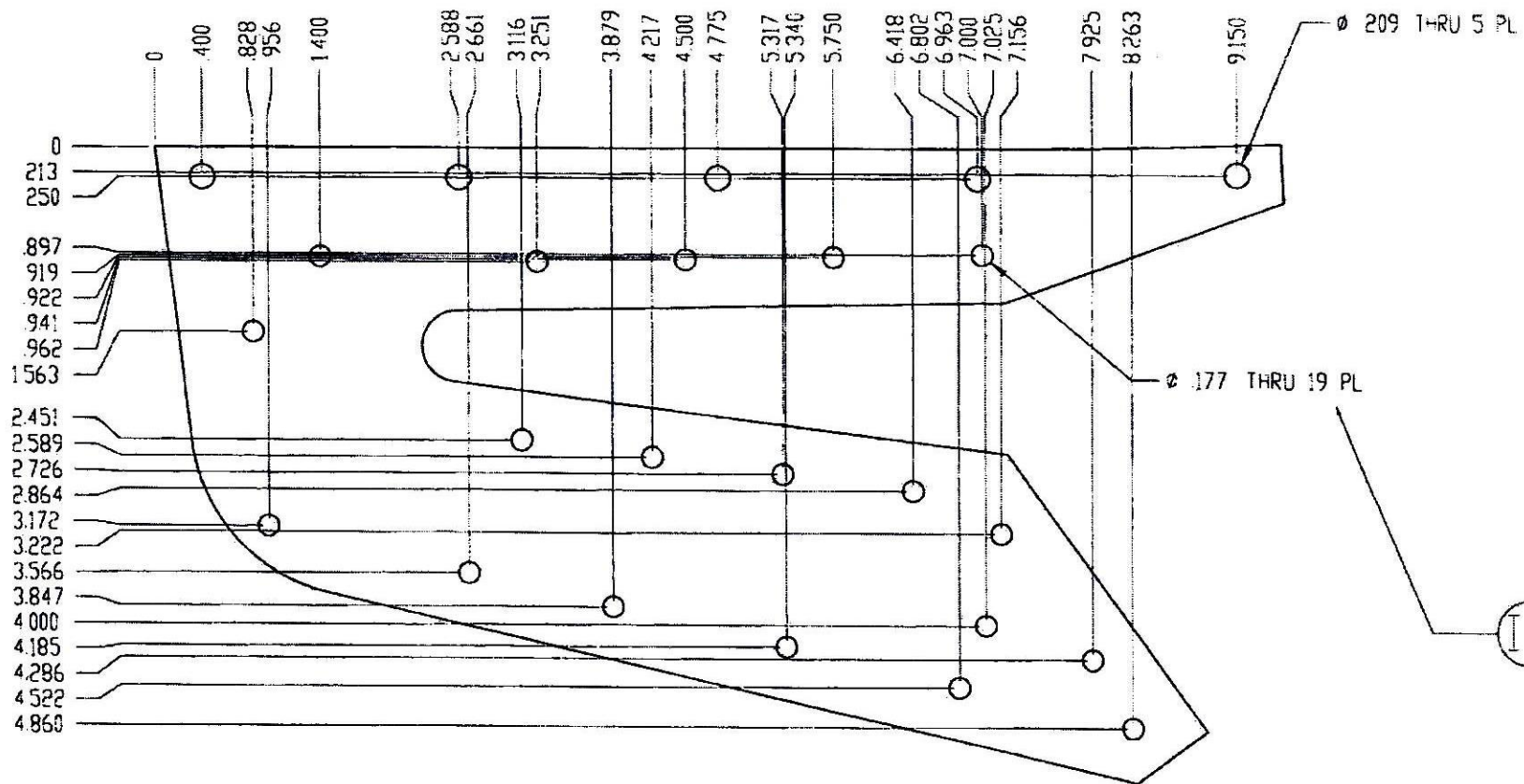


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148591 M5

1607-12

10	R	601.1541	19	LOCKNUT	MS21042L08
9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			.3001		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM					
			CHANGE CATEGORY ☐ MAJOR ☒ MINOR		DER REVIEW REQUIRED ☐ YES ☒ NO

SHEET 3 IS:

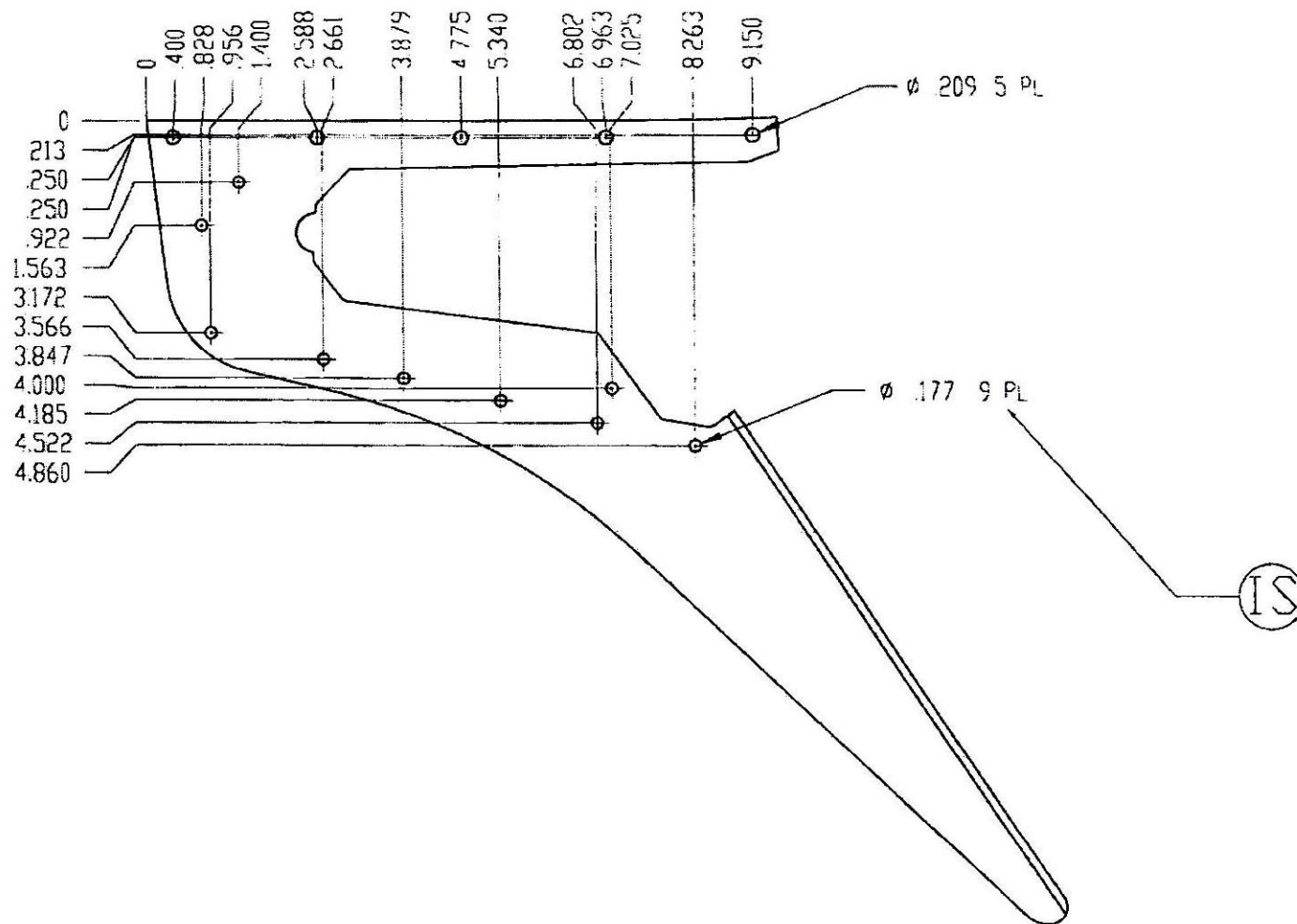


SECTION A-A

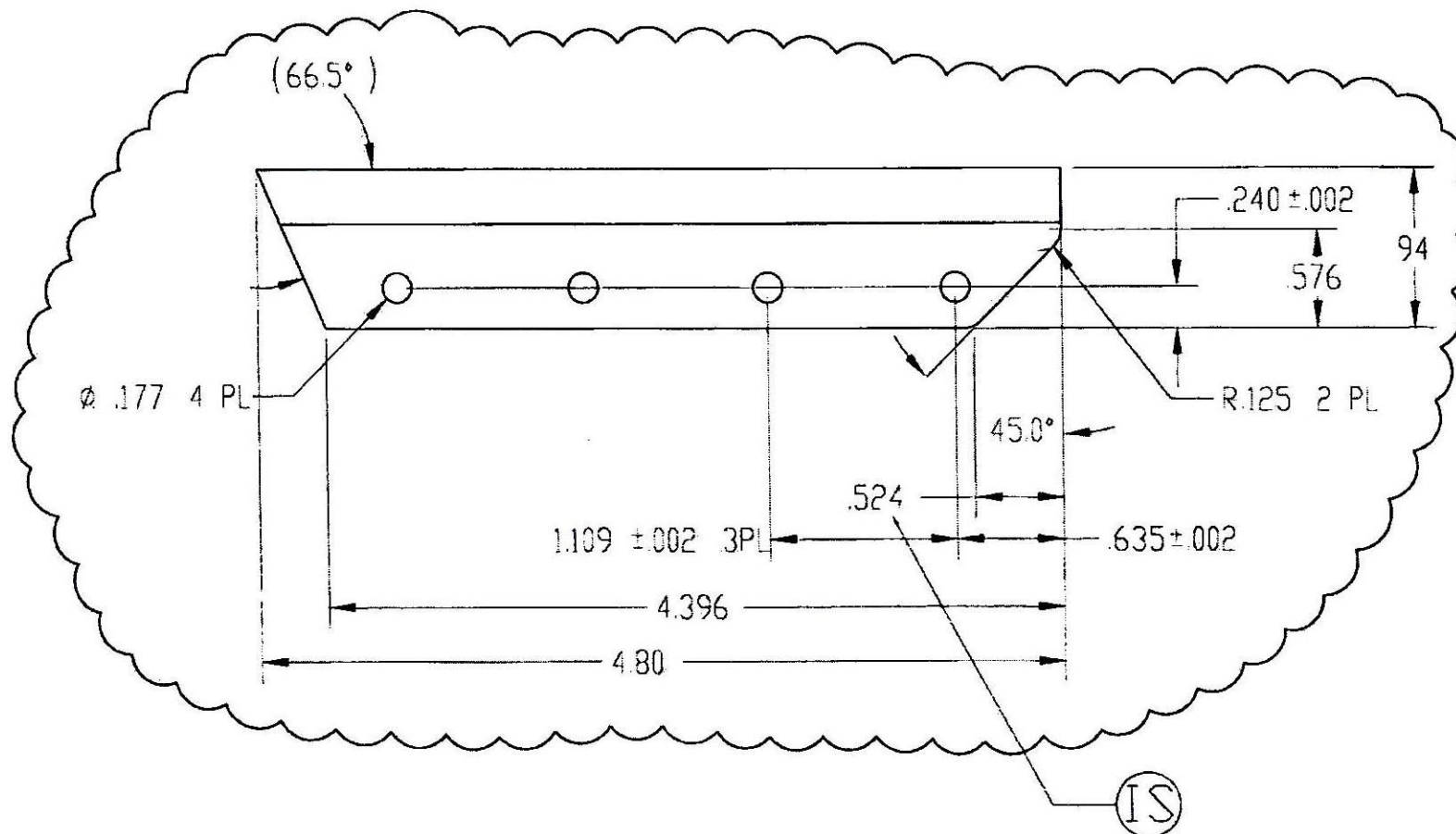


F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 5 IS:



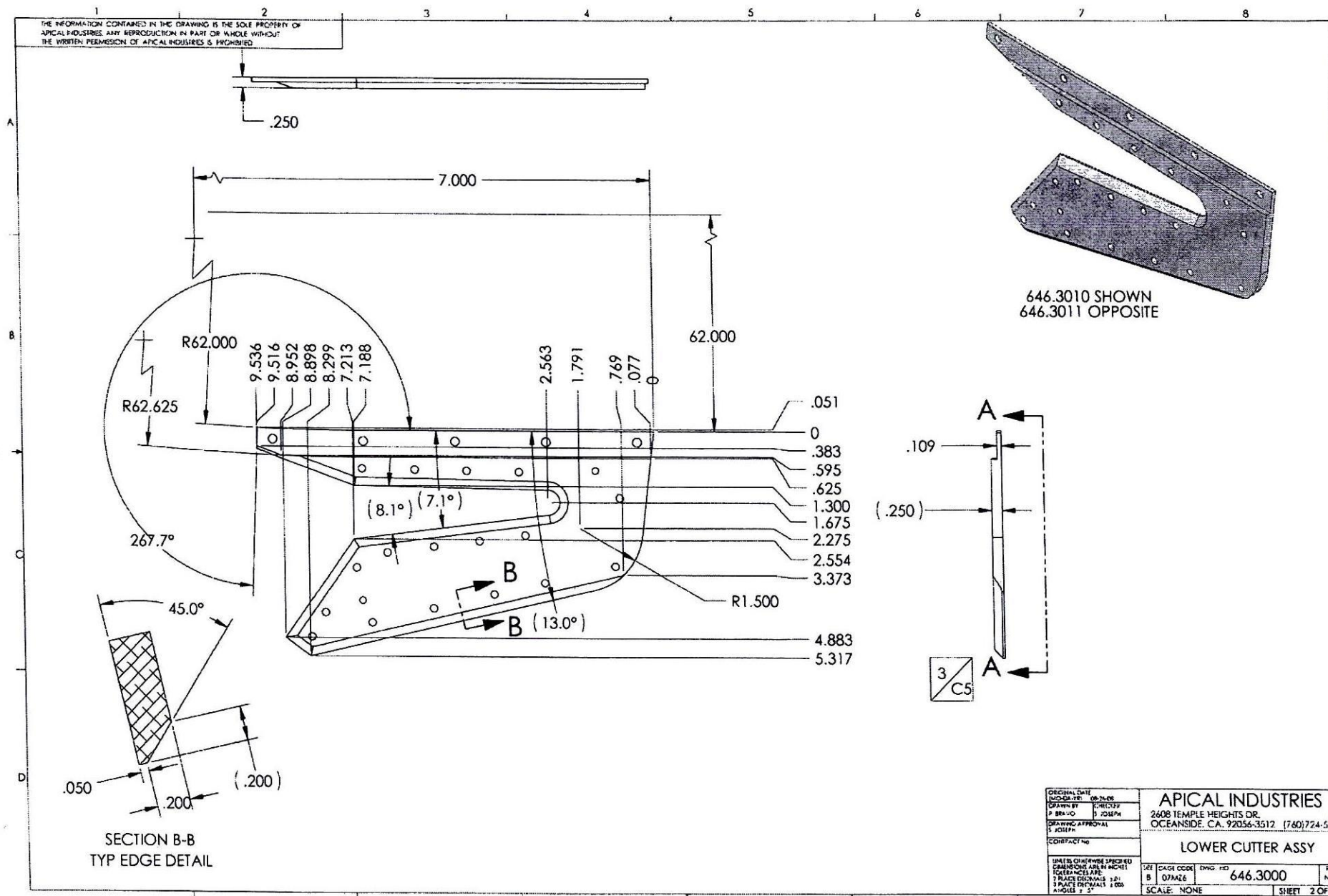
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 6, ZONE C4, IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
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SHEET 1 OF 6

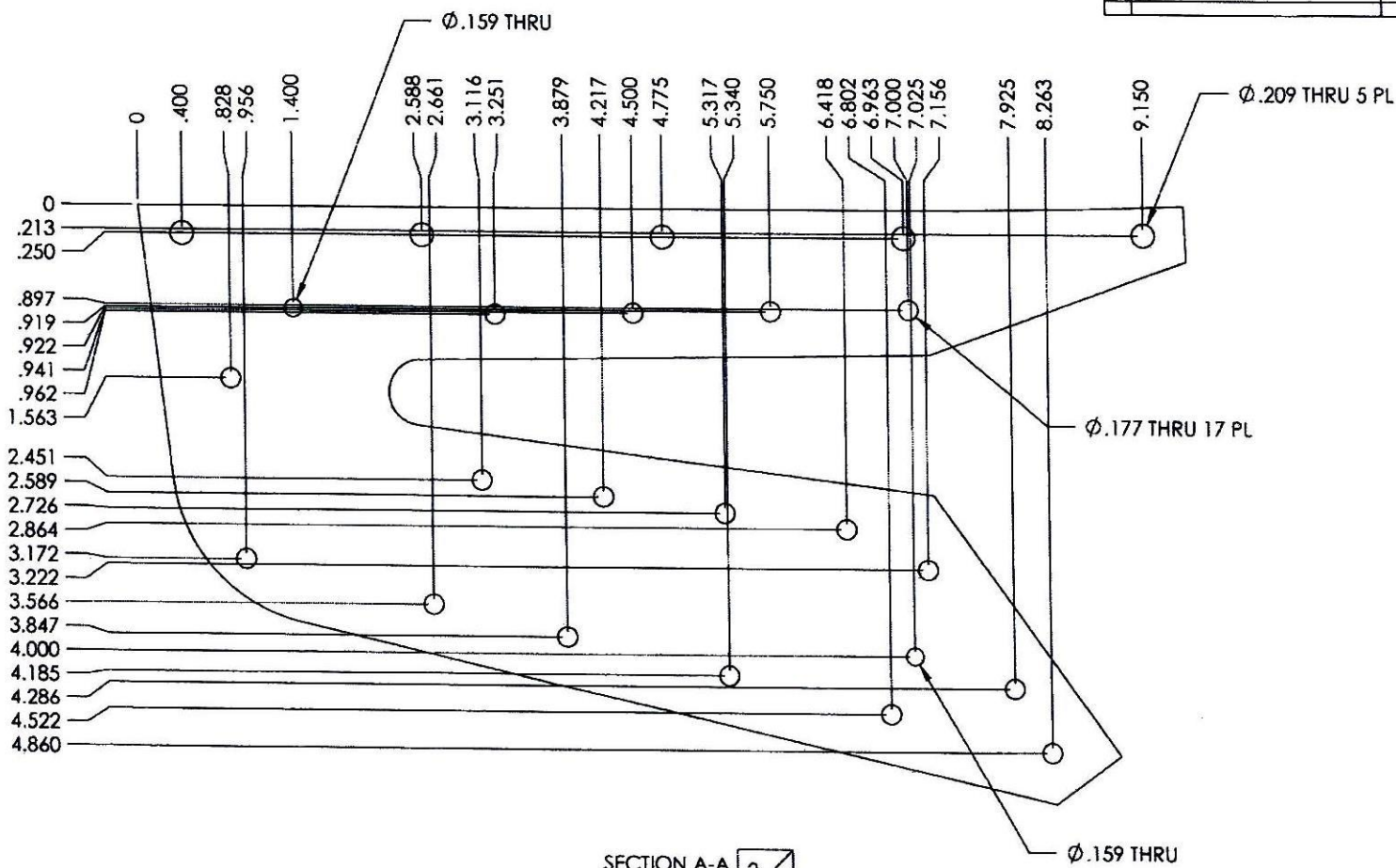
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ORIGINAL DATE UNLESS NOTED OTHERWISE		APICAL INDUSTRIES	
DRAWN BY P. BRUNO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY J. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.		SEE CAGE CODE	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. PLACES DECIMALS 1.01 2. PLACES THIRDS 1.00 3. PLACES THIRDS 1.00 ANGLES 1.0		B 07/02/86	646.3000 N/C
SCALE: NONE		SHEET 2 OF 2	

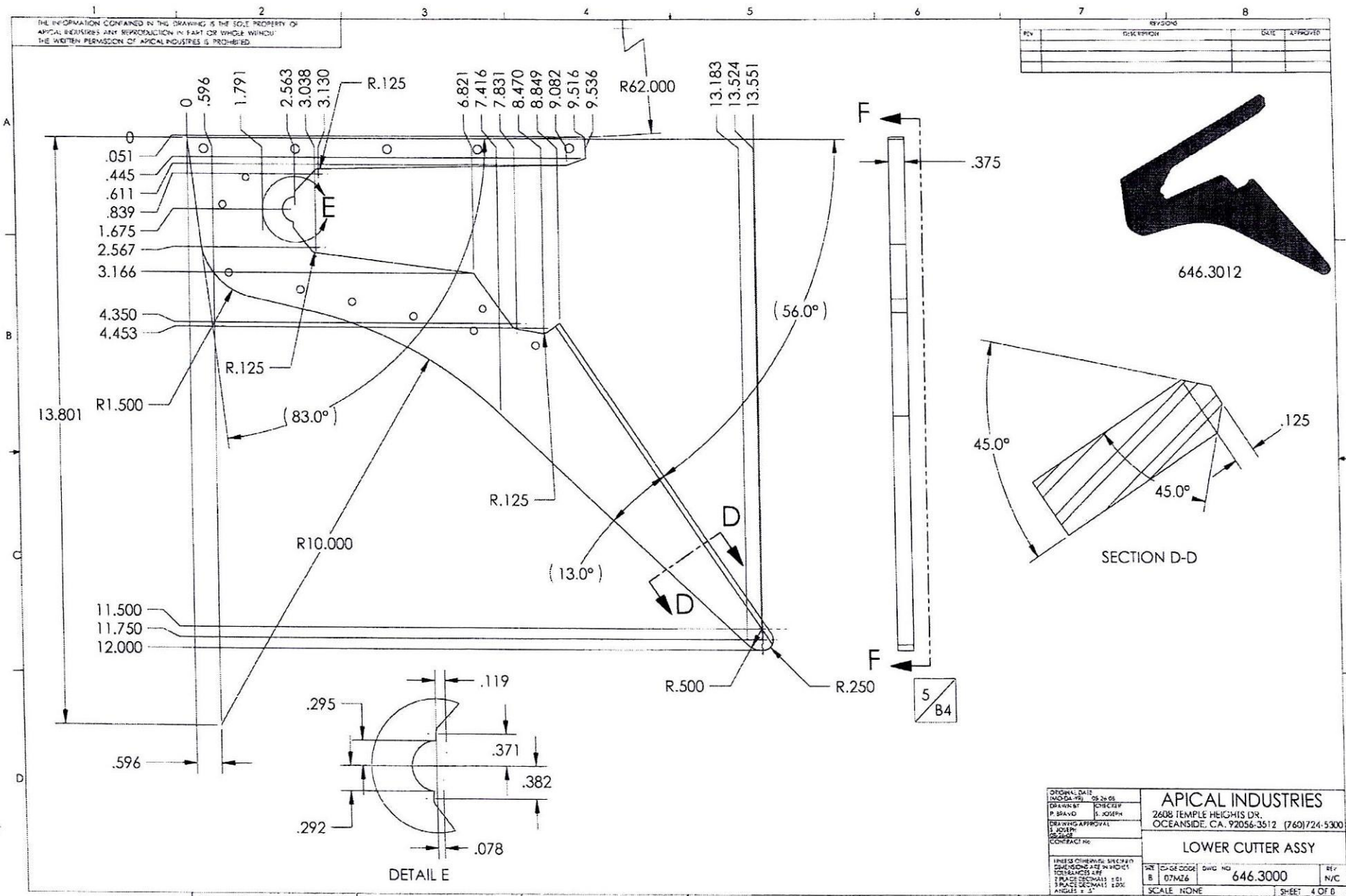
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REV	DESCRIPTION	DATE	APPROVED



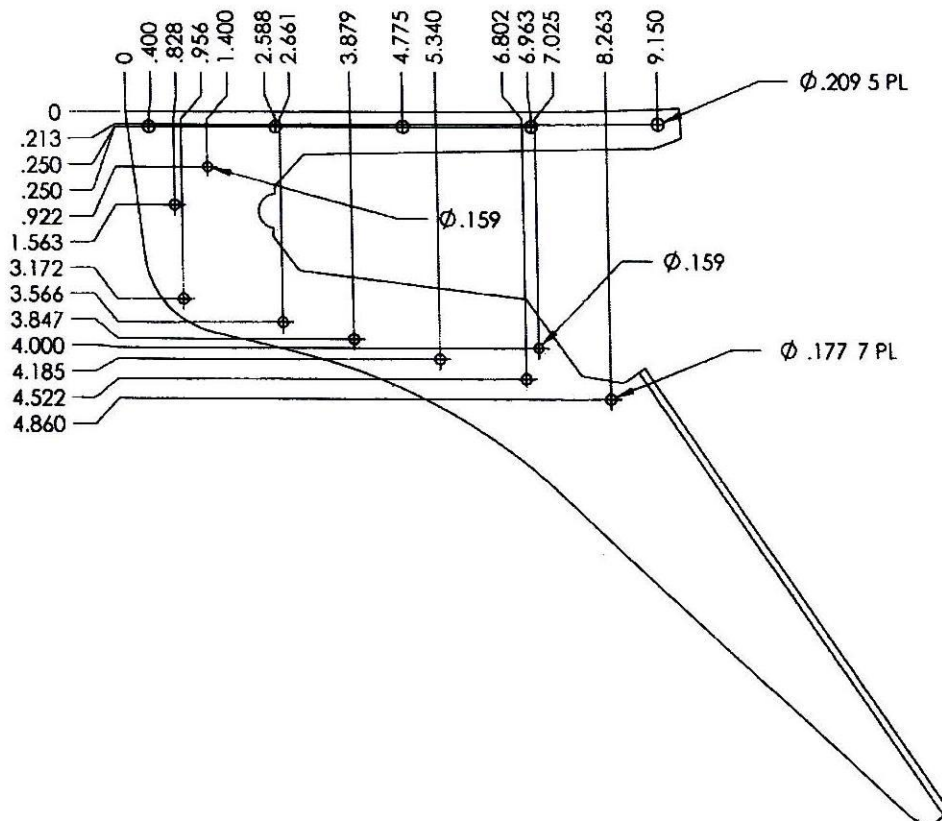
2
C7

ORIGINAL DATE 08-24-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300
DRAWN BY P. BRAYO	DESIGNED BY S. JOSEPH
CHECKED BY S. JOSEPH	DATE 07/14/16
APPROVED BY S. JOSEPH	DWG NO 646.3000
SCALE NONE	REV. N/C
SHEET 3 OF 8	



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REV.	DESCRIPTION	DATE	APPROVED

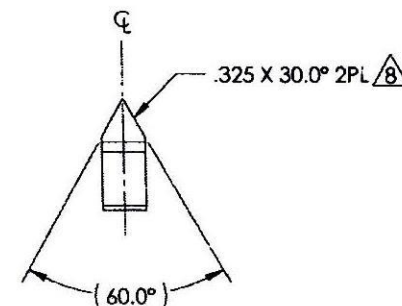
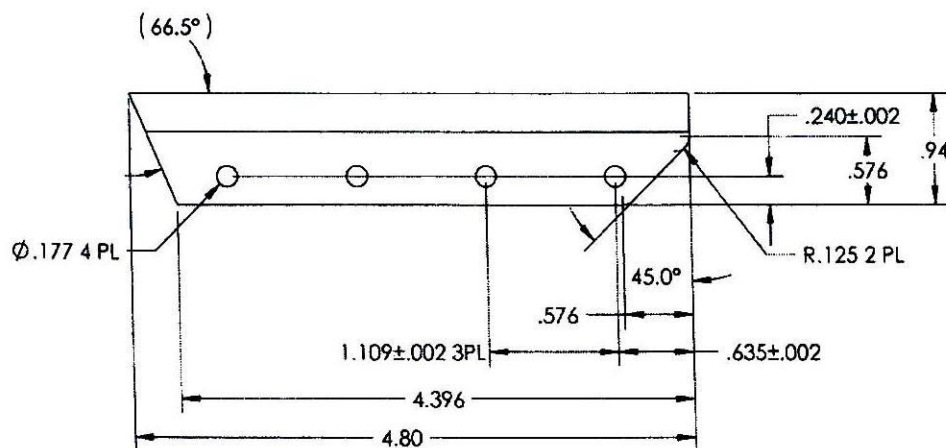
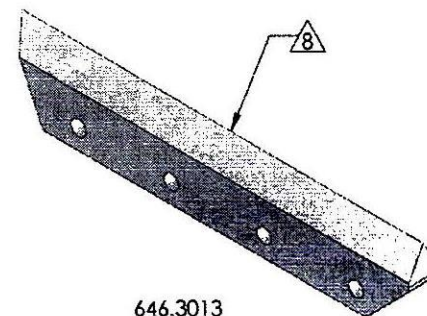
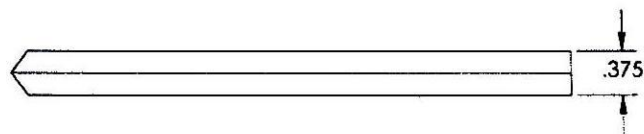


SECTION F-F 4
B6

ORIGINAL DATE: 08-23-08 DRAWN BY: J. JOSEPH P. BRAYNO J. JOSEPH GRAPHIC APPROVAL: J. JOSEPH CONTRACT NO.				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°				LOWER CUTTER ASSY	
REV.	CHG CODE	CHG NO.	DATE	REV.	DATE
8	07M26	646.3000		N/C	
SCALE: NONE				SHEET 5 OF 8	

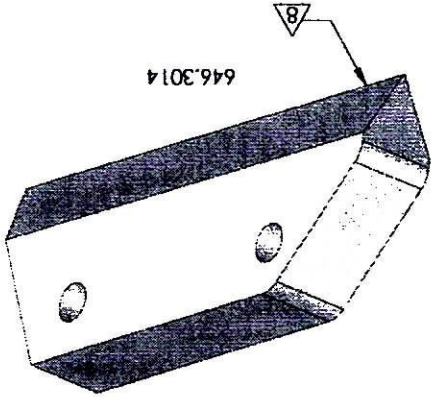
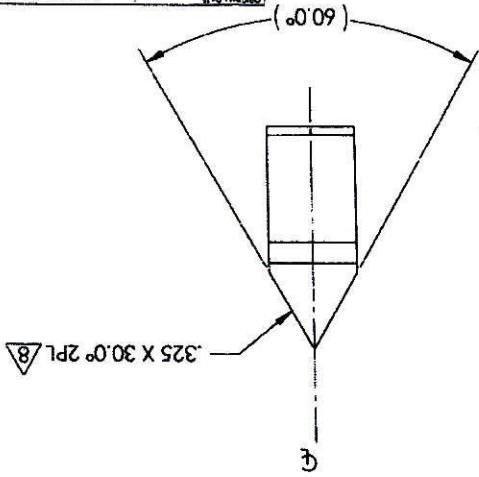
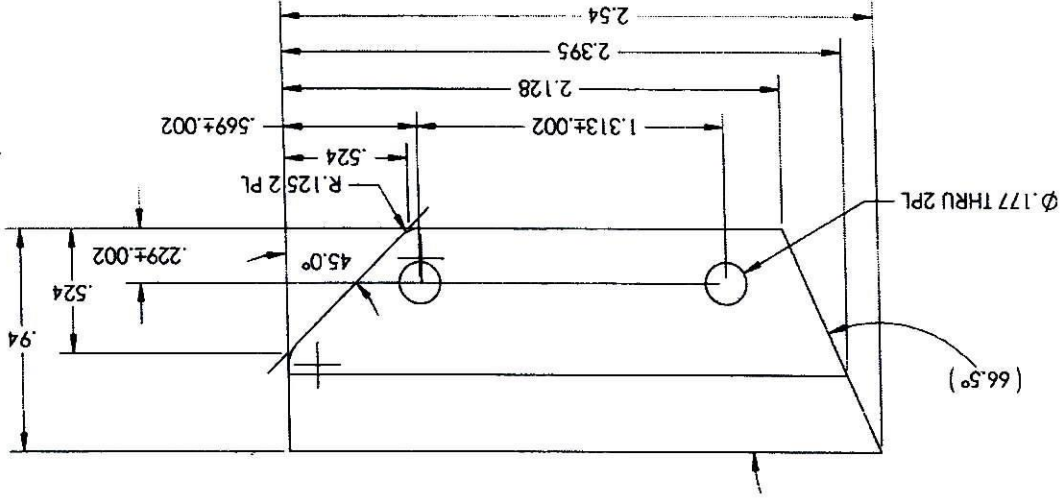
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REVISION			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE: 08-29-08		APICAL INDUSTRIES	
DRAWN BY: J. JOHNSON		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. JOHNSON		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: J. JOHNSON		LOWER CUTTER ASSY	
REV: 0		646.3000	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 2 PLACES DECIMALS ± .001 ANGLES: 1°-15°		SCALE: NONE	SHEET 6 OF 8

SPR	DESCRIPTION	DATE	AMOUNT

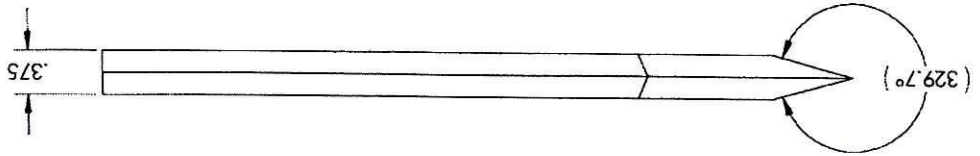
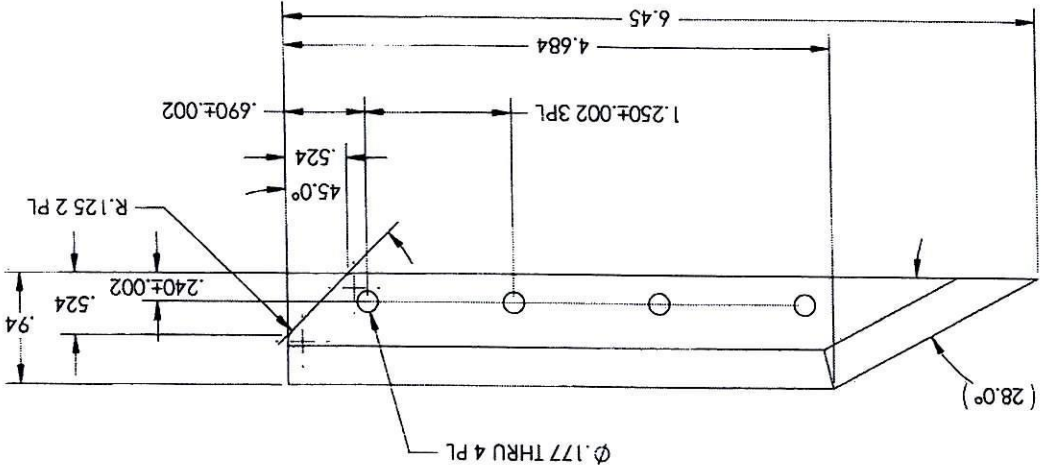
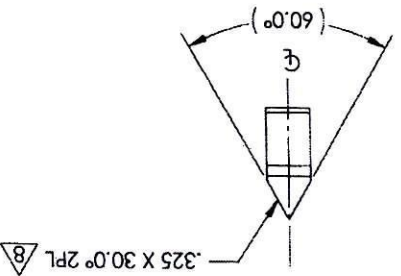
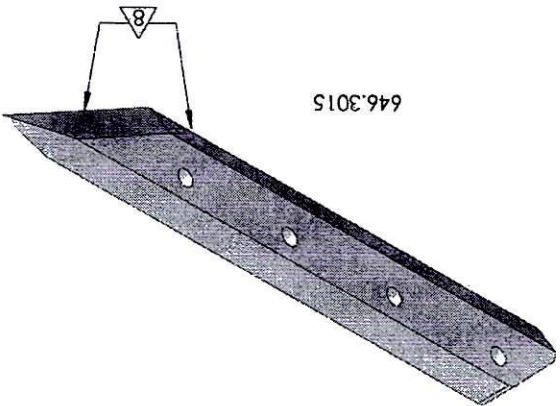


646.3014

APICAL INDUSTRIES	2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-2512	(760) 774-5300
LOWER COUNTRY ASSY		
DATE CODE CODE	DWG NO.	QTY
888	646.3000	N/C
SHEET 7 OF 8	SCALE NONE	

DATE	APPROVED
DESIGNER	
CHECKER	
DATE	

6	7	8
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APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR
OCEANSIDE, CA, 92056-3512 (760) 774-5300

LOWER CUTTER ASSY

SCALE NONE

SHEET 8 OF 8

REV B 07/24/26 DWG NO 646.3000

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